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D3916-041
Job Sheet 199431



Part No: D3916-041

Job Qty: 4 pcs

Part Name: Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/22/19

Job Tracking No:

Due Date: 9/9/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	4 pcs	9/9/19	9/9/19	0.00	1.82	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
105	QC 5	4 pcs	9/9/19	9/9/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
107	Large Fab - Basket - 2 -	4	9/9/19	9/9/19	0.00	2.29	QC 5 - 61		
							QC 5 - 81		
							Large Fab - 1 - B4B		



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Container No: S216613



Part: D3916-041

Job No: 199431

Serial No/Batch: S216613

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/24/19

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B4B	pcs				Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	MAL
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
110 QC 5	4 pcs	9/9/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	DAS 24 9-89
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
120 QC 10	4 pcs	9/9/19	0.00	0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	DAS 24 9-89
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
130 Packaging 3-1 - Stock - B4B	4 pcs	9/9/19	0.00	0.00	QC 10 - 9	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	DAS 24 9-89
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	4	9/9/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

DAS

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OCT 01 2019

Part Op 100 - 1- Cut tube 50" 2- Bend tube with manuel pipe bender as per DT9567 *** Make line at 9.00" and use jig for other Descriptions: lines, and ensure seam in place on side of tube when bending*** 3- Trim access tube material to finish size as per dwg D3916 4- Drill and chamfer holes as per dwg D3916-1 using DT9605

105 - (QC5- Inspect part completeness to step on W/O)

107 - (Weld per dwg A/R S.S. rod Batch: 11139015 1- weld bushing as per dwg D3916 2- grind welds flush

110 - (QC5- Inspect part completeness to step on W/O)

120 - (QC10- Inspect visual per QSI004- ground welds)

130 - (Identify as per dwg & Stock Location: _____) LOCATION: WA004-5

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3759-1	Bushing	28 pcs (7 ea)	100-Large Fab - Basket - 1	<u>5209589</u>
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	16.6640 ft (4.166 ea)	100-Large Fab - Basket - 1	<u>5201990</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D3759-1	28	47	0
	M304TS0.750W.049	17	435	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____		DISPOSITION		DEPARTMENT/PROCESS				Engineering ☐	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube Machining ☐ Large Fab ☐		Cross tube Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Water Jet Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRR (QS1042)					
Description Work Order Deviation		Disposition		Completed By		Lead hand / Supervisor			
						QC / QA Coordinator			
Root Cause		FAULT CATEGORY							
Operator ☐		Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Folio/Program ☐		Outside Tolerance ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Grain Direction ☐		Drawing ☐	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Finish ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐		Misread ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐			
Human Factors ☐		Other/Details: _____							